

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019640**Date Inspected:** 23-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

**WELDING**

This QA Inspector observed the following work in progress:

**BAY 14**

During random in process inspection of OBG Segment 13BW, this QA Inspector observed that the Deck panel diaphragm to Deck panel diaphragm splice joints SEG3014B-001, SEG3014C-001 at panel point 122 and SEG3014D-001, SEG3014E-001 at panel point 121.5 had full length cracks after back gouging. This QA Inspector informed ZPMC Quality Control (QC) Inspector identified as Mr. Sun Tian Liang of this issue. Mr. Sun Tian Liang informed this QA Inspector that the full length cracks on the above mentioned weld joints would be corrected in a manner compliant with the contract documents. See attached pictures.

This QA Inspector observed ZPMC qualified welding personnel identified as 066398 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 14W. Weld joint is identified as SEG3020M-004. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and welding repair report B-WR19827.

This QA Inspector observed ZPMC qualified welding personnel identified as 067942 perform repair welding by

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Shielded Metal Arc Welding (SMAW), on OBG Segment 14W. Weld joint is identified as SEG3020BB-010. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and welding repair report B-WR20164.

This QA Inspector observed ZPMC qualified welding personnel identified as 066695 perform repair welding by Flux Cored Arc Welding (FCAW), on OBG Segment 14W. Weld joint is identified as SEG3020BB-028. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-FCAW-2G (2F)-ESAB-Repair-FCM and Critical welding repair report B-CWR2750.

This QA Inspector observed ZPMC qualified welding personnel identified as 067609 perform welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 14W. Weld joint is identified as SEG3020AX-017, 022. ZPMC Quality Control (QC) Inspector identified as Li Ming Yang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM.

This QA Inspector observed ZPMC qualified welding personnel identified as 066236, 201215 perform welding by Flux Cored Arc Welding (FCAW), on OBG Segment 14W. Weld joint is identified as SEG3020M-188/189. ZPMC Quality Control (QC) Inspector identified as Li Ming Yang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2132-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 066734 perform welding by Flux Cored Arc Welding (FCAW), on OBG Segment 13BW. Weld joint is identified as SEG3014B-016/017. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 067275 perform welding by Flux Cored Arc Welding (FCAW), on OBG Segment 13BW. Weld joint is identified as SEG3014D-004/005. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

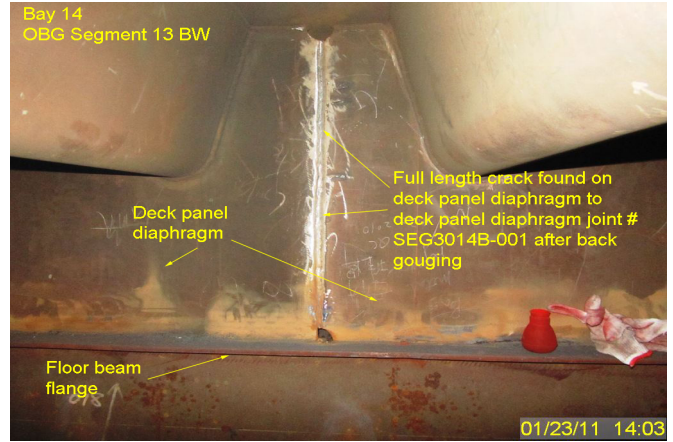
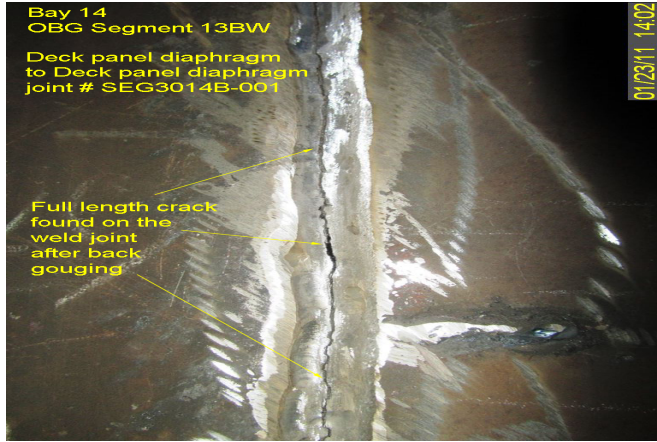
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, phone: 15000422372 , who represents the Office of Structural Materials for your project.

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**Inspected By:** Upadhye, Anand

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer